

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002157**Date Inspected:** 20-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

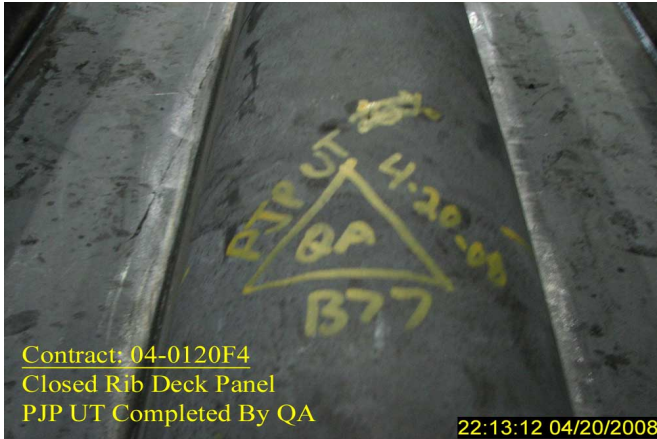
On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) Inspector Edward Leach was present to randomly observe and document the welding and Quality Control (QC) functions performed by ZPMC personnel relative to the fabrication of SAS Superstructure project. While on site, the QA Inspector noted the following work.

Bay 1

The QA Inspector performed ultrasonic testing (UT) for approximately 15% of the partial joint penetration (PJP) weld lengths on the closed ribs of deck panel designations DP273-001 and DP086-001. The QA Inspector performed UT for weld joints 001 through 006 for both panels and compiled the results on a TL-6027 modified UT report. While performing the UT, the QA Inspector documented the following information; indication screen height percentage, indication length, lack of penetration (LOP), Y coordinates, depth of penetration (DOP) and material thickness measurements where the indication was marked. The QA Inspector verified each area that ZPMC UT personnel previously marked up while performing their 15% UT evaluation. Once the UT was completed, the QA Inspector used a yellow paint marker on the top of each closed rib to indicate the UT was completed for each weld (see digital photos below). Based on the 15% UT evaluation performed on this date, it appeared that the UT performed by ZPMC for these deck panels met the general requirements of the contract specifications. The QA Inspector also generated the TL-6027 modified UT report on this date.

WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Leach,Ed	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
